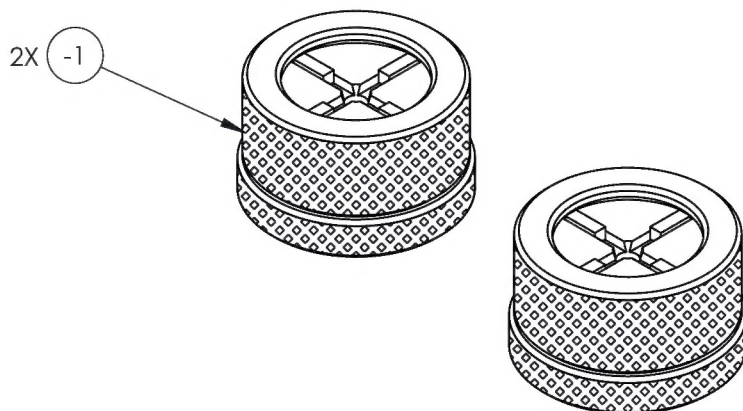


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	10/10/2016	DPD	JAG



#### NOTES:

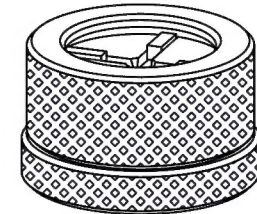
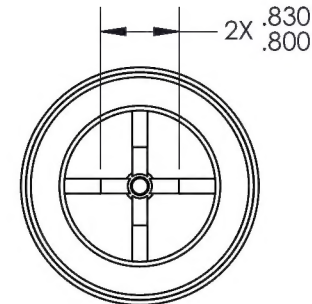
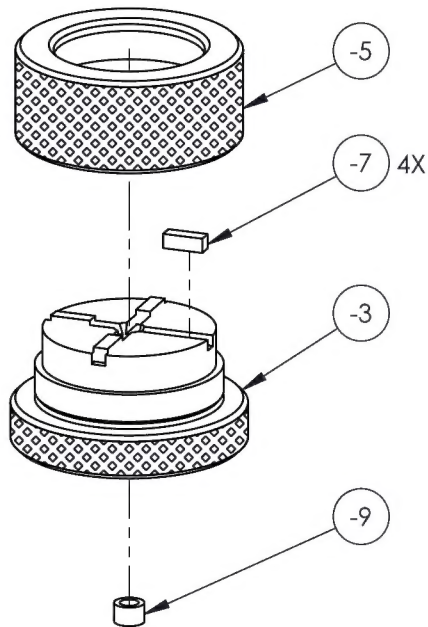
1. REF. EUROCOPTER T/N: 105-40001W1.
2. USED ON MODELS:  
EC135, EC145, EC635, EC645, H135.

<b>DART</b> AEROSPACE																	
TITLE <b>STAKING TOOL RETAINER</b>																	
DWG NO. <b>RBE105-40001W1</b>	REV <b>1</b>																
<table border="1"> <tr> <td>MAT'L</td> <td rowspan="4">           UNLESS OTHERWISE SPECIFIED            DIMENSIONS ARE IN INCHES            .XXX ± .005 FRACTIONS ± 1/8            .XX ± .01 ANGLES ± .5°            .X ± .1 SURFACES = 125°            1. BREAK ALL SHARP EDGES            .015 x 45° OR .015R            2. DIMENSIONAL LIMITS APPLY            AFTER PLATING            3. INTERPRET DIM AND TOL PER            ASME Y14.5M-2009         </td> </tr> <tr> <td>TREAT</td> </tr> <tr> <td>FINISH</td> </tr> <tr> <td>SPEC</td> </tr> <tr> <td>DRAWN BY: <b>DUERFELDT</b></td> <td rowspan="4">           USED ON MODEL  <b>SEE NOTE 2</b> </td> </tr> <tr> <td>CHECKED: <b>CLOUGH</b></td> </tr> <tr> <td>OPPS APPR: <b>ANDERSON</b></td> </tr> <tr> <td>QA APPR: <b>LINDSAY</b></td> </tr> <tr> <td>APPROVED: <b>GILBERT</b></td> <td></td> </tr> <tr> <td>SCALE <b>1:2</b></td> <td>DATE <b>1/19/2016</b></td> </tr> <tr> <td colspan="2">SHEET 1 OF 6</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	TREAT	FINISH	SPEC	DRAWN BY: <b>DUERFELDT</b>	USED ON MODEL <b>SEE NOTE 2</b>	CHECKED: <b>CLOUGH</b>	OPPS APPR: <b>ANDERSON</b>	QA APPR: <b>LINDSAY</b>	APPROVED: <b>GILBERT</b>		SCALE <b>1:2</b>	DATE <b>1/19/2016</b>	SHEET 1 OF 6	
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																
TREAT																	
FINISH																	
SPEC																	
DRAWN BY: <b>DUERFELDT</b>	USED ON MODEL <b>SEE NOTE 2</b>																
CHECKED: <b>CLOUGH</b>																	
OPPS APPR: <b>ANDERSON</b>																	
QA APPR: <b>LINDSAY</b>																	
APPROVED: <b>GILBERT</b>																	
SCALE <b>1:2</b>	DATE <b>1/19/2016</b>																
SHEET 1 OF 6																	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING TOOL RETAINER ASSEMBLY			2
	1		-3		BASE	4140/4142		3
	1		-5		RETAINING RING	4140/4142		4
	4		-7		SLIDING PAD	S.S.	4mm X 4mm X 12" (MCMASTER-CARR #90457A420) MODIFIED	5
	1		-9		INSERT	NYLON		6
		B/O	-11	1	PISTOL CASE	PLASTIC	RSR GROUP #10137	N/S
	ASSY -1							

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



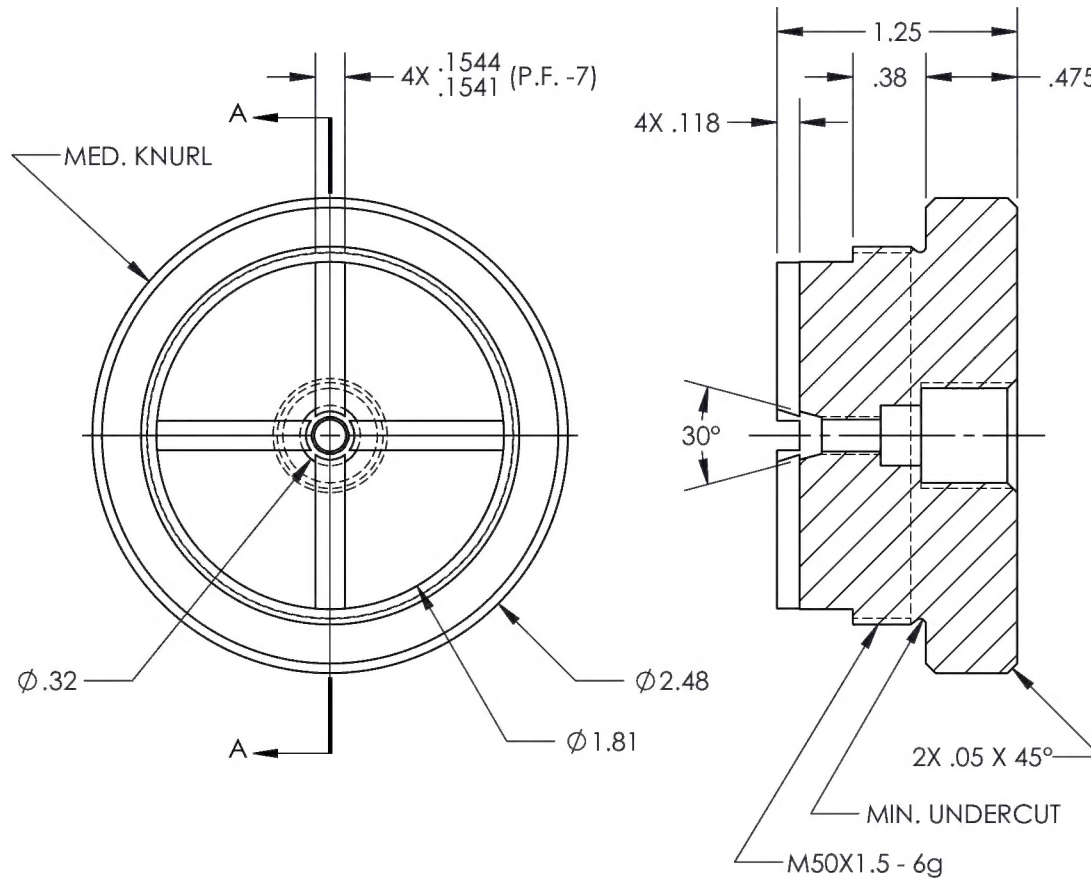
(-1)

STAKING TOOL RETAINER ASSEMBLY

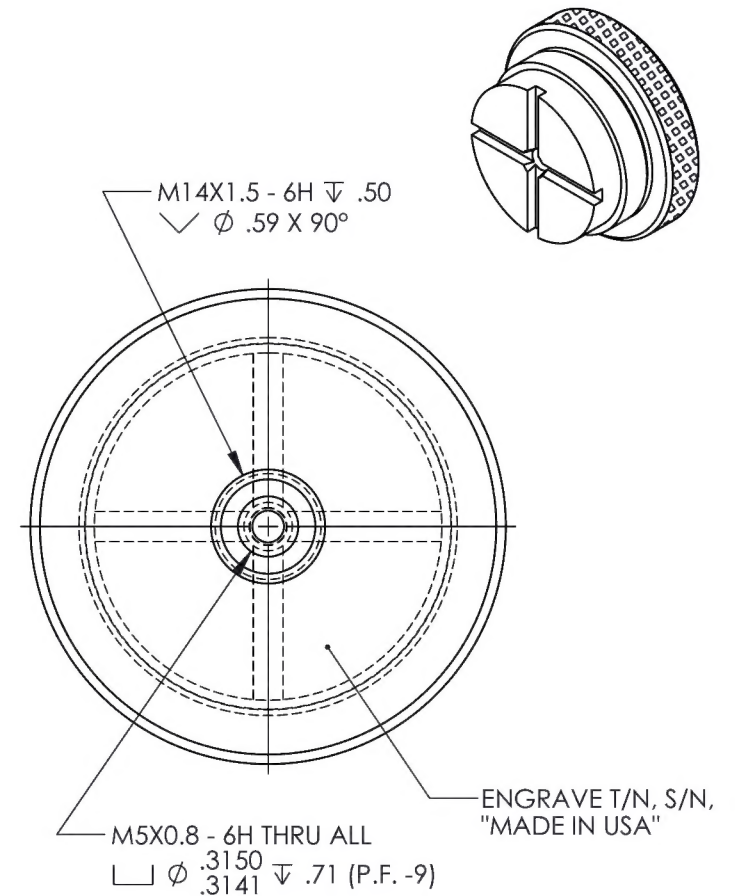
<b>DART</b> AEROSPACE	
TITLE STAKING TOOL RETAINER	
DWG NO. RBE105-40001W1-1	REV 1
MAT'L REAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	SEE SHEET 1 NOTE 2
SCALE 1:2	DATE 1/19/2016
	SHEET 2 OF 6

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



SECTION A-A

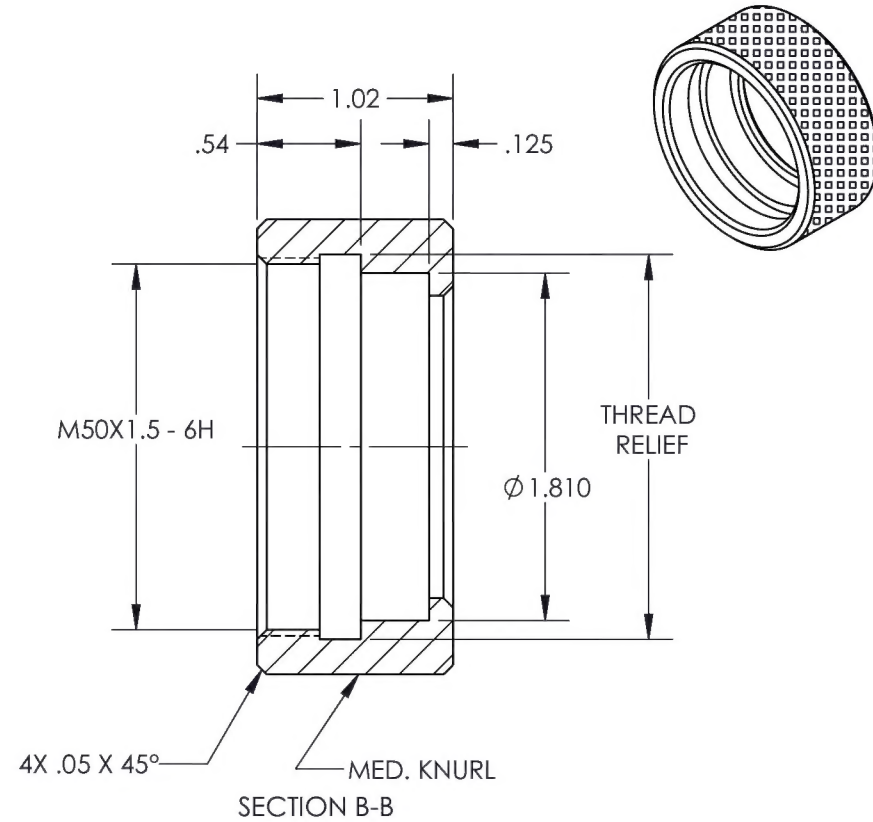
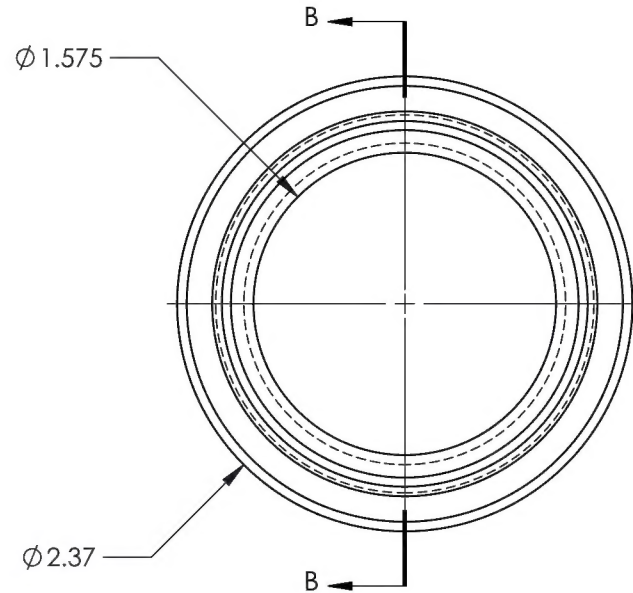


(-3)  
BASE

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-3</b>	REV <b>1</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 45-50	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 1/19/2016
SHEET 3 OF 6	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

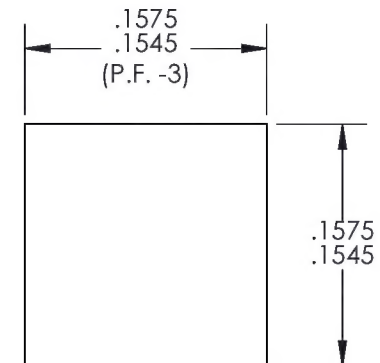
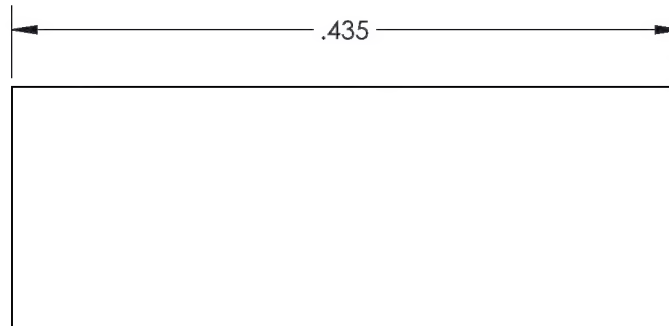
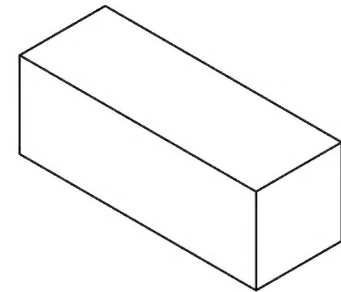


(-5)  
RETAINING RING

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-5</b>	REV <b>1</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 45-50	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 1/19/2016
	SEE SHEET 1 NOTE 2
	SHEET 4 OF 6

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	

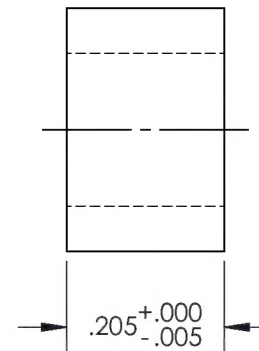
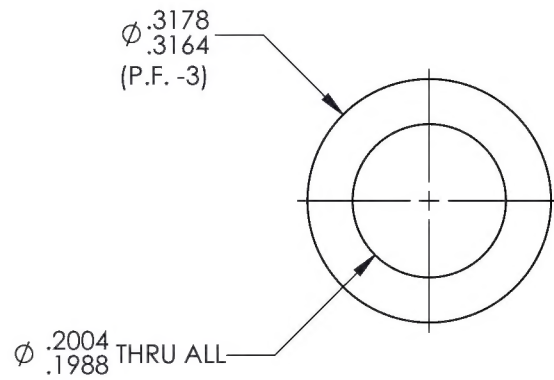
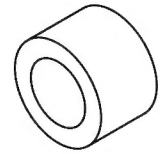


(-7)  
SLIDING PAD

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-7</b>	REV <b>1</b>
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 8:1	DATE 1/19/2016
	SHEET 5 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-9)

INSERT

<b>DART</b> AEROSPACE	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-9</b>	REV <b>1</b>
MAT'L NYLON	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
SPEC	.XX $\pm$ .01 ANGLES $\pm$ 5°
	.X $\pm$ .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	SEE SHEET 1 NOTE 2
SCALE 4:1	DATE 7/12/2016
	SHEET 6 OF 6



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. RBE101-40001W1-3/-5/-9/-11  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td></td> </tr> </table>				Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																		
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																		
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																		
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																			
Date : _____	Step #: _____	QTY Effective : _____		<b>MRB (QSI042) Approval</b>  March 29, 2018																	
<b>Description Work Order Deviation</b>		<b>Disposition</b>		<b>Completed By</b>																	
- RBE101-40001W1-3/-5 can be manufactured from 17-4PH-H900 as an alternative material  - If manufactured from SS, Heat treat is no longer applicable  - If manufactured from SS, Zinc plate is no longer applicable  - RBE101-40001W1-9 material call-out is vague, manufacture from M-Delrin-R or MT-Nylon 6-R.  - Replace RSR Group Case 10137 with Black Pelican 1050 Case		- This deviation is acceptable.  - The drawings will be updated to reflect these changes.  - The fit, form and function of the tool will be as originally intended.		<b>Lead hand / Supervisor Approval Verification</b>																	
				<b>QC / QA Coordinator Approval</b>																	
<b>Root Cause</b>		<b>FAULT CATEGORY</b>																			
Environment <input type="checkbox"/> Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input checked="" type="checkbox"/> <b>X</b> Internal Transport <input type="checkbox"/> Tribal Knowledge <input type="checkbox"/> LOA <input type="checkbox"/> Substation <input type="checkbox"/> Past Expiry Date <input type="checkbox"/> Misidentified <input type="checkbox"/>	No Re-verification <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Use for Testing <input type="checkbox"/> Poor Information <input type="checkbox"/> Rushing <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Past Due <input checked="" type="checkbox"/> <b>X</b>	Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/> Set-up <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Drill Holes <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set <input type="checkbox"/> Misabeled <input type="checkbox"/> Fit/Function <input type="checkbox"/> Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Misread <input type="checkbox"/> Turning Sequence <input type="checkbox"/>																
OTHER : _____																					